









Work Order ID 62994

Friday, October 15, 2010 9:44:56 AM

Page 1

Item ID: D3825-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Rib Assembly (Basket End)
Start Date: 10/15/2010 Start Qty: 6.00  Cust Item ID:
Required Date: 10/21/2010 Req'd Qty: 6.00  Customer:

Reference:

Approvals: Process Plan:  Date: 10/10/15 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3825	Rev A

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R S.S. Rod Batch: m111585

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

SAD: 10-10-15

⑥

LPL 10-10-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62994

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Page 2

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Required Date:	10/21/2010	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00		10.10.19		6	0		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				6			10.10.19
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WT</u> Memo	0.00 0.00		SAD 10-10-19		6			

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Page 3

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/10/2010
ME
10-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 15, 2010 9:45:00 AM

Page 1

Work Order ID: 62994

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)



Start Date: 10/15/2010


Required Date: 10/21/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3  Spacer Bushing		Manufactured	No			100	Each	33.0000	1	6			
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Pl 10.10.18

Location	Loc Qty	Loc Code
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WA	33	
58974	1	
60320	1	
60952	11	
62108	20	

D3759-1  Bushing		Manufactured	No			100	Each	72.0000	1	6			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Pl 10.10.18

Location	Loc Qty	Loc Code
----------	---------	----------

ST084	21	
56942	21	
WA	51	
54072	9	
61379	42	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, October 15, 2010 9:45:00 AM

Page 2

Work Order ID: 62994



Parent Item: D3825-041



Parent Item Name: Rib Assembly (Basket End)

Start Date: 10/15/2010

Required Date: 10/21/2010

Start Qty: 6.00

Required Qty: 6.00

M304TS0.750W.065

Purchased

No

100

f

678.6362

2.125

13.42105



SAD 10-10-15

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT

662.0818

112398

0

114482

0.0002

115494

82.0816

115593

580

WA

16.554385

114520

0.527385

115274

16.027

13.42105

W/O:		WORK ORDER CHANGES					
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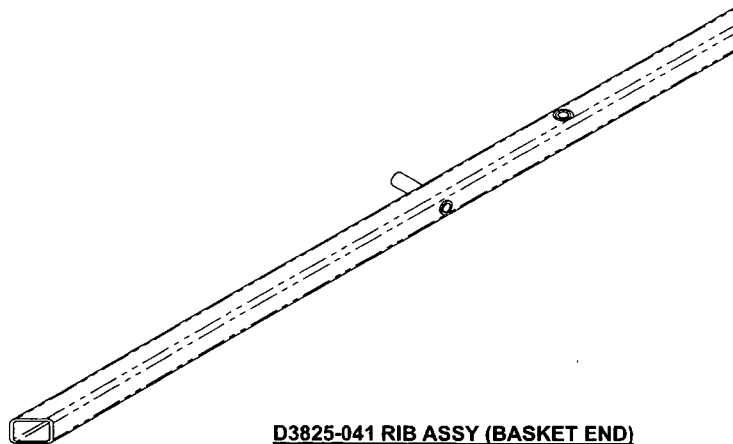
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB

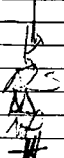


D3825-041 RIB ASSY (BASKET END)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO CHANGE
WITHOUT NOTICE
NO. 62994
28/10/15

RELEASED
03/11/15

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.22 lbs
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	08.09.23
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3825	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		RIB ASSY (BASKET END)	NTS	
DATE	08.09.23		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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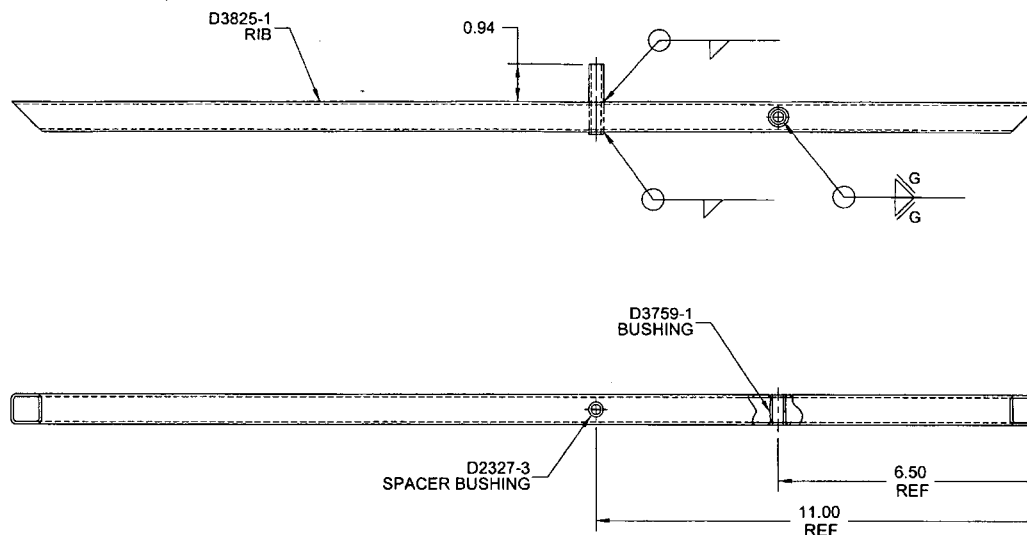
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3825-041 RIB ASSY (BASKET END)

Wb 4204

RELEASED
06/11/18 NTS

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO. D3825	REV. A
MFG. APPR.	<i>AS</i>		SHEET 2 OF 3
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	RIB ASSY (BASKET END)	NTS
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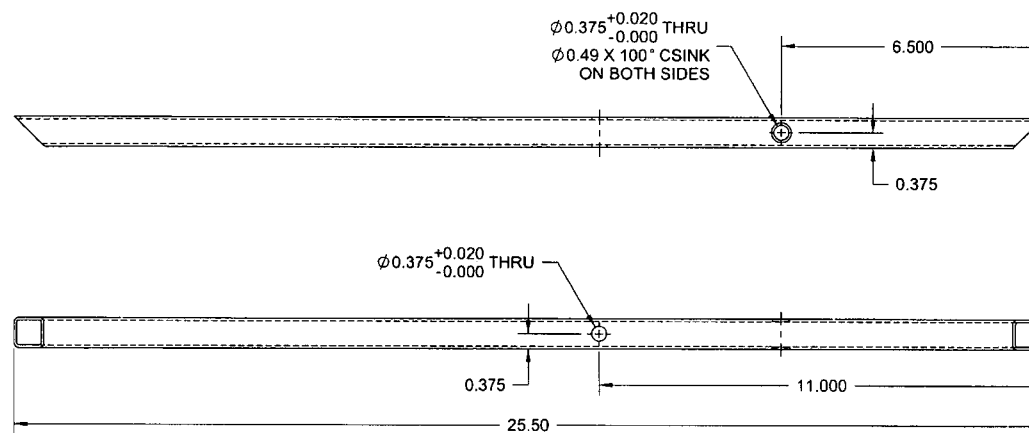
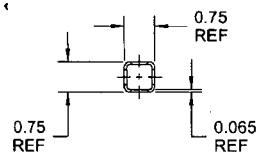
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NOTE: Date & initial all entries



D3825-1 RIB

w/o 62994

RELEASED
08/11/13

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3825
MFG. APPR.		REV. A
APPROVED		SHEET 3 OF 3
DE APPR.		TITLE RIB ASSY (BASKET END)
DATE	08.09.23	SCALE NTS

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